

Date: Monday, 21/07/2008 8:04:14 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SKI
Job Number	40674			
Estimate Number	13481			
P.O. Number			Part Number	D37951
This Issue	21/07/2008	S.O. No.	Drawing Number	D3795 PREL DATED 06.07.21
Prsht Rev.	NC		Project Number	N/A
First Issue			Drawing Revision	PREL
Previous Run			Material	
Written By			Due Date	28/07/2008
Checked & Approved By	08-07-21		Qty:	3
Comment	Um: Each Est Rev:A New Issue 08-07-18 JLM Verified By:DD			

## Additional Product

## PRELIMINARY ISSUE

POSITIVE RECALL

EFFECTIVE

POSITIVE  
RECALL

RELEASED

DATE

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 6.2345 sf(s)/Unit Total : 18.7034 sf(s)

UHMW 1" Black

Batch: 108645 1B 8-7-22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg File d3795-1 Blank

1B 8-7-22

(3)

2-Deburr if necessary

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA765 Rev: AA & Dwg D3795 Rev: A

H.A 08/07/24

2-Deburr per dwg D3795

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 08/07/24

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

2/08-08-18

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SK1

Job Number: 40674

Part Number: D37951

Job Number:



Seq. #: Machine Of Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_



4107f

ENGINEERING  
APPROVAL

08.08.08

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/09 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Chapt 1  
08/08/08  
Wf

POSITIVE RECALL

EFFECTIVE 08.08.08 AUTH 4  
RELEASED \_\_\_\_\_ DATE 08.08.08  
08.08.08

DART AEROSPACE LTD	Work Order:	40674
Description: SK1	Part Number:	D 3795 - 1
Inspection Dwg: D3795 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.380	+/- .030	0.377	✓			
0.95	+ .030 / -.010	0.960	✓			
0.75	+ .030 / -.010	0.752	✓			
0.25	+ .030 / -.010	0.256	✓			
R0.25	+/- .030	R 0.25	✓			
6.62	+/- .030	6.621	✓			
3.40	+/- .030	3.391	✓			
R0.25	+/- .030	R 0.25	✓			
R 2.64	+/- .030	R 2.64	✓			
0.20	+ .030 / -.010	0.195	✓			
0.38	+ .030 / -.010	0.380	✓			
5.000	+/- .010	5.000	✓			
0.063 x 45°	+/- .010	0.056 x 45°	✓			
0.050 x 45°	+/- .010	0.049 x 45°	✓			
0.063 x 45°	+/- .010	0.058 x 45°	✓			
0.19 x 45°	+/- .030	0.185 x 45°	✓			
4.00	+/- .030	4.001	✓			
0.050 x 45°	+/- .010	0.050 x 45°	✓			
0.95	+ .030 / -.010	0.958	✓			
0.25	+ .030 / -.010	0.258	✓			
Ø0.93 x 0.30↓	+/- .030	Ø0.928 x 0.304↓	✓			
1.56	+/- .030	1.565	✓			
7.000	+/- .010	7.001	✓			

Measured by:	H. A	Audited by:		Prototype Approval:	
Date:	08/07/24	Date:	106.08.18	Date:	08.08.18

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	40674
Description: SK1	Part Number:	D3795-1
Inspection Dwg: D3795 Rev: A		Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## First Article Prototype

Measured by:	<u>J.A</u>	Audited by:	<u>J.J</u>	Prototype Approval:	<u>J</u>
Date:	<u>08/07/24</u>	Date:	<u>09.08.20</u>	Date:	<u>08.08.16</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

D

**REFERENCE ONLY**

D

8

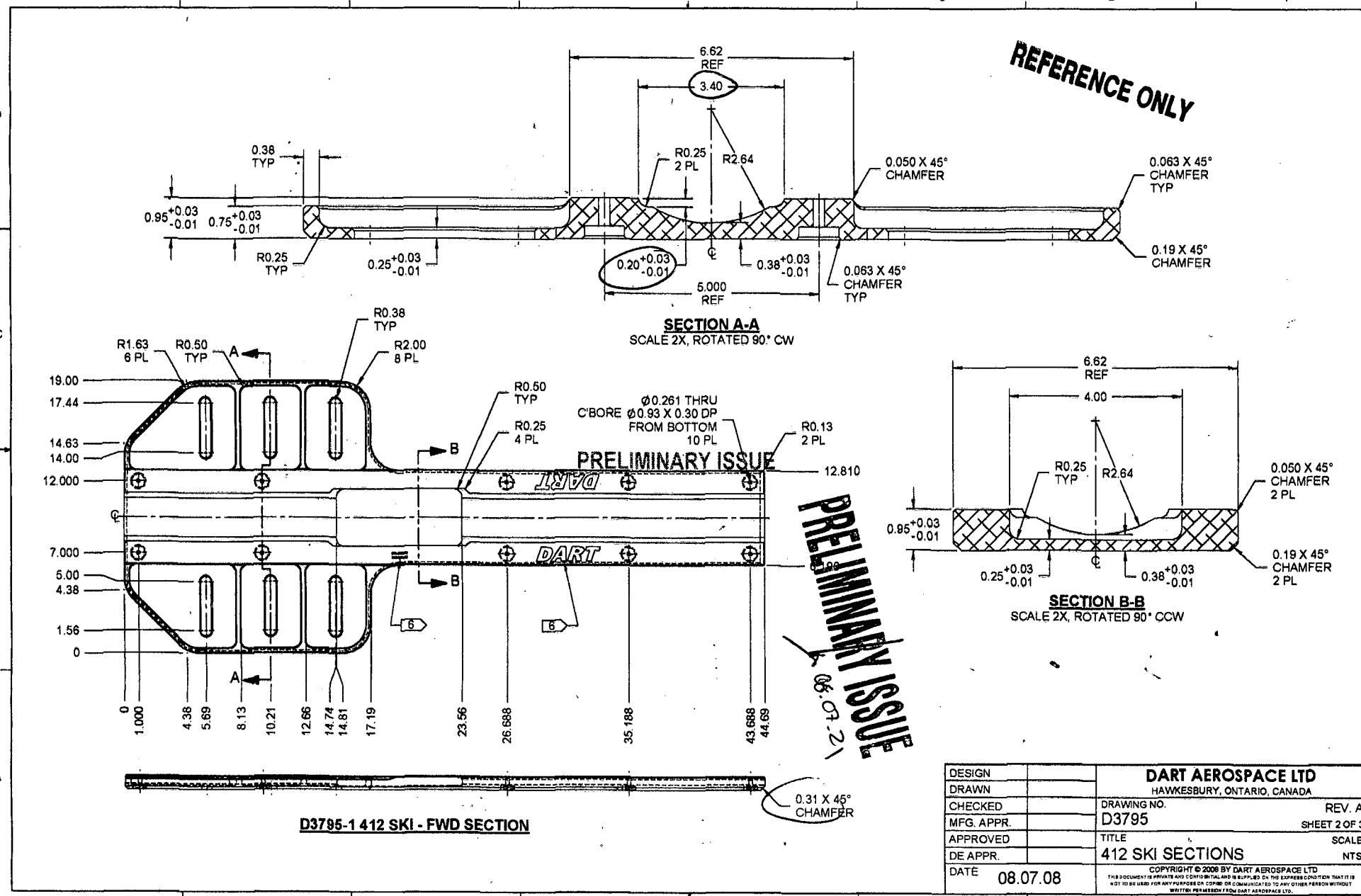
2

B

B

A

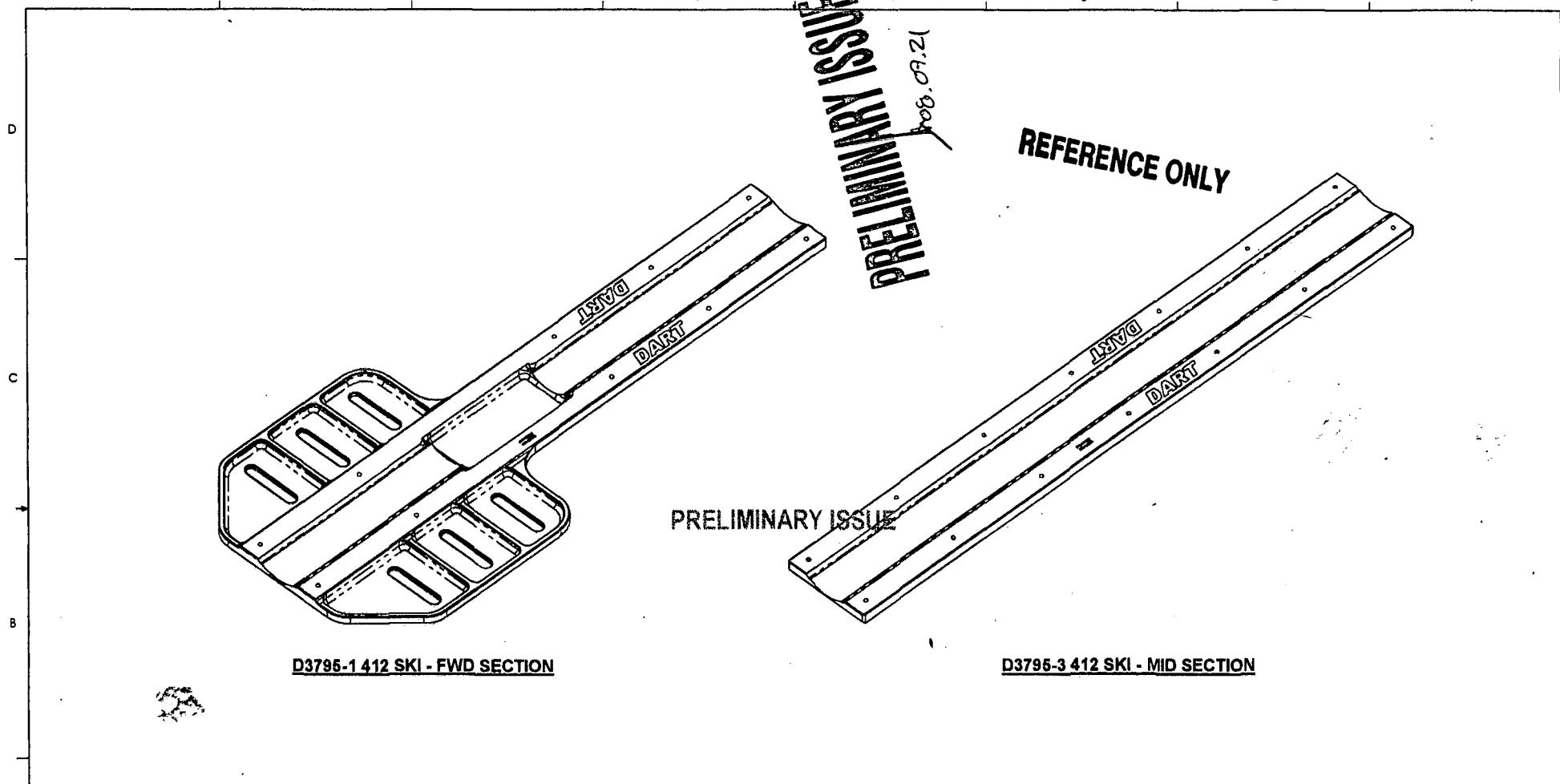
A



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3795	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		412 SKI SECTIONS	
DATE	08.07.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



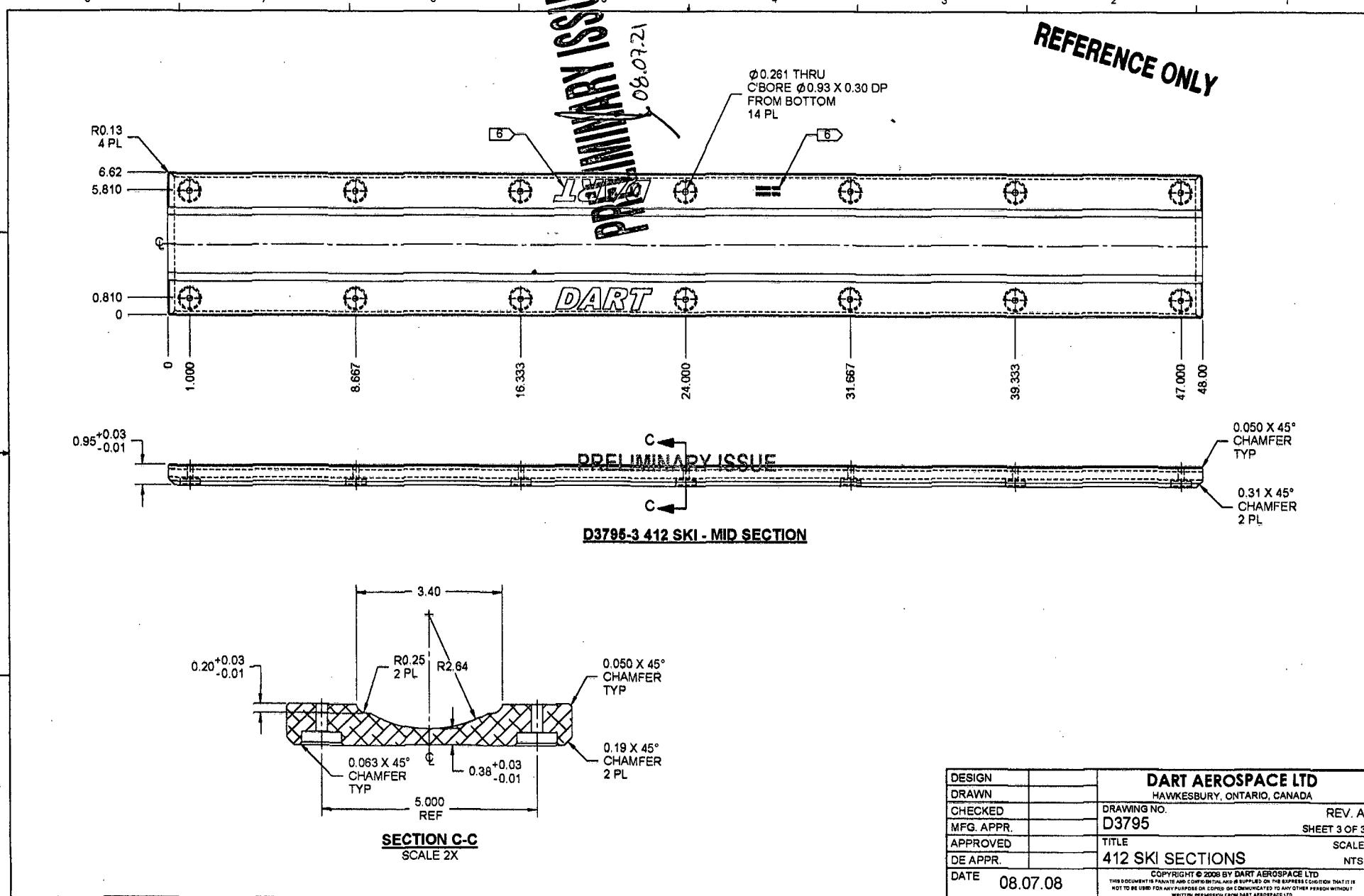
NOTES:  
 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL  
 REF DART SPEC MUHMWB

2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: - ENGRAVE WITH DART P/N "D3795-X" AND B/N "BXXXXX" USING 0.13 HIGH LETTERS TO MAX DEPTH OF 0.010  
 - ENGRAVE WITH DART LOGO USING 1.00 HIGH LETTERS TO MAX DEPTH OF 0.012  
 7) WEIGHT: D3795-1 = 9.37 lbs  
 D3795-3 = 7.87 lbs

A	NEW ISSUE	MB	08.07.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3795	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		412 SKI SECTIONS	NTS
DATE	08.07.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

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D

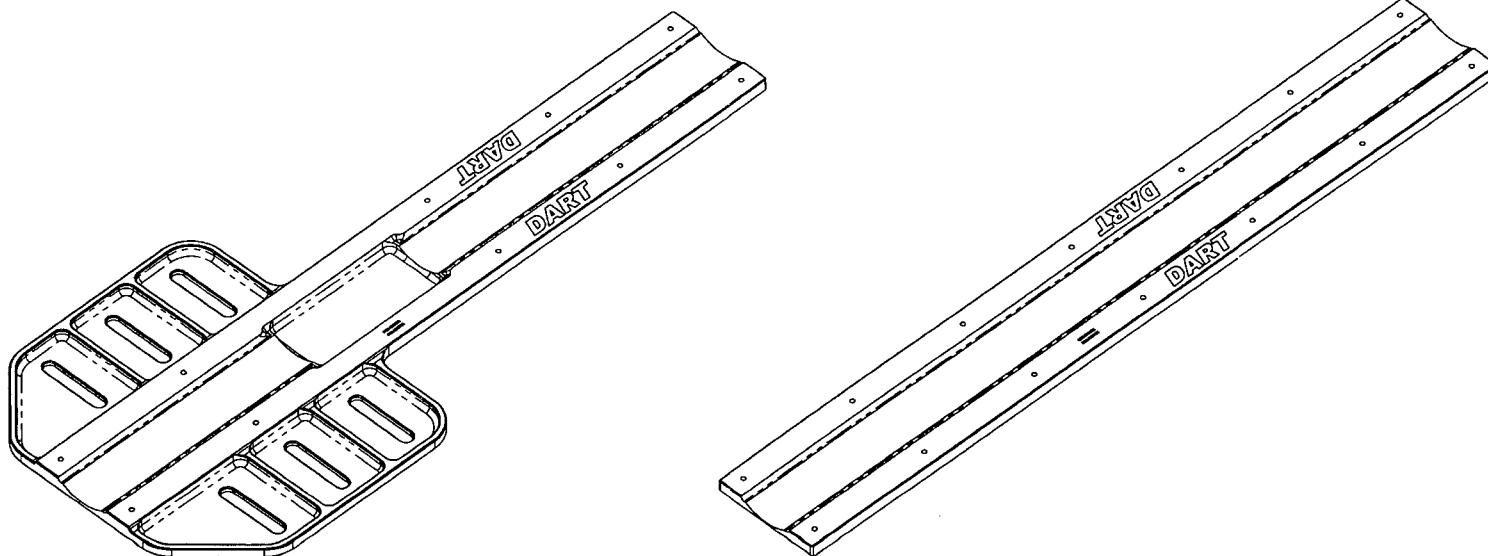
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B



D3795-1 412 SKI - FWD SECTION

D3795-3 412 SKI - MID SECTION

RELEASED  
08-07-07 11:11

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL  
REF DART SPEC MUHMWB
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REV.	BY	DATE	
DESIGN	<i>1b</i>		
DRAWN	<i>1b</i>		
CHECKED	<i>1b</i>		
MFG. APPR.	<i>JL</i>		
APPROVED	<i>JL</i>		
DE APPR.	<i>JL</i>		
DATE	08.07.08		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

REV. A  
D3795  
SHEET 1 OF 3  
TITLE  
412 SKI SECTIONS  
NTS

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